



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

648.4704

Job Sheet 180409



Part No: 648.4704

Job Qty: 1 ea

Part Name: C45 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 8/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG OM & OOPM-C45 Rev 4 (648.4704) IPP Rev A 18.04.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/7/18	0.00	0.00	Start Up Small Fab-3		MAD DAS 38 9-88
100	Small Fab	1 pcs		8/7/18	0.00	1.00	Small Fab-3		
120	QC	1 pcs		8/7/18	0.00	0.00	QC4		
121	DC	1 pcs		8/7/18	0.00	0.00	DC		MAD ET 9-88
130	Packaging	1 pcs		8/7/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		8/7/18	0.00	0.00	QC21		

Part Op 100 - Pick bag and tag

Descriptions: 121 - Supply owner's & overhaul procedures manual

AUG 27 2018
LA sold

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
NAS1149F0463P	Washer -	3 Ea (3 ea)	90-Start up Operation	5036461
NAS1149F0563P	Washer -	8 Ea (8 ea)	90-Start up Operation	5067901-1
188-FPSS-1/4 20-3/8	see P/N 188-FPSS-1/4-20-3/8 -	2 Ea (2 ea)	100-Small Fab	5048557
188-FSCS-1032-5/8	Screw -	4 Ea (4 ea)	100-Small Fab	5066767
600-1309-A	Label	1 Ea (1 ea)	100-Small Fab	5073105
600.1312	Caution Sticker -	1 Ea (1 ea)	100-Small Fab	FIQ3174-40
AN4-23A	Bolt -	2 Ea (2 ea)	100-Small Fab	5071344
AN5-21A	Bolt -	4 Ea (4 ea)	100-Small Fab	5057170
C2-14-2	Label Rivets -	2 Ea (2 ea)	100-Small Fab	50291293
C45-10-1 P	Spring Pin -	1 Ea (1 ea)	100-Small Fab	5048643
C45-10-2	Lock Spring -	1 Ea (1 ea)	100-Small Fab	5029297
C45-11-2 P	Locating Pin -	2 Ea (2 ea)	100-Small Fab	5091795
C45-12-1	Lock Bushing -	2 Ea (2 ea)	100-Small Fab	5088946
C45-12-6	Retaining Ring -	2 Ea (2 ea)	100-Small Fab	502805101278
C45-13-1	Keeper Bushing -	2 Ea (2 ea)	100-Small Fab	5027746
C45-13-2	Spacer -	2 Ea (2 ea)	100-Small Fab	5053218
C45-13-5	Keeper Spring -	1 Ea (1 ea)	100-Small Fab	5091768 P 5029314
C45-3-1 P	Radial Bearing -	2 Ea (2 ea)	100-Small Fab	5091768
C45-3-12	DU Bearing -	1 Ea (1 ea)	100-Small Fab	5093408
C45-3-2-1	Snap Ring -	2 Ea (2 ea)	100-Small Fab	5068056
C45-3-4-1	Retaining Ring -	4 Ea (4 ea)	100-Small Fab	5029245
C45-3-5	Spacer -	2 Ea (2 ea)	100-Small Fab	5078570
C45-3-8A	Actuator Shaft Bushing -	1 Ea (1 ea)	100-Small Fab	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																											
Date : _____		QTY Effective : _____		MRB (QSI042) Approval _____																																																																																									
Description W		UAKI AEROSPACE Container No: S105370 Part: 343 4704 Job No: 180409 Serial No/Batch: S105370 Revision: 4 Inspector: _____ Exp Date: _____ Instructions: _____ Date: 08/27/10		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																									
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td style="width:15%;">Environment</td><td style="width:15%;">☐</td><td style="width:15%;">No Re-verifica</td><td style="width:15%;">☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Que</td><td>☐</td></tr> </table>		Environment	☐	No Re-verifica	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Que	☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">☐ Crimp/Kink/Ripple/Wave</td> <td style="width:15%;">☐ Inspection Incomplete/Unqualified</td> <td style="width:15%;">☐ Wrong Stock Pulled</td> <td style="width:15%;">☐ Positioned Wrong</td> </tr> <tr> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Part Moved</td> </tr> <tr> <td colspan="3"></td> <td>☐ Drawing</td> </tr> <tr> <td colspan="3"></td> <td>☐ Finish</td> </tr> <tr> <td colspan="3"></td> <td>☐ Misread</td> </tr> <tr> <td colspan="3"></td> <td>☐ Turning Sequence</td> </tr> </table>				☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Positioned Wrong	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Outside Dimensions	☐ Crushing	☐ Countersink	☐ Off-set	☐ Over/Under tolerance	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Part Incorrect	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Part Moved				☐ Drawing				☐ Finish				☐ Misread				☐ Turning Sequence
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C45-3-8B	Actuator Shaft Bushing ✓	1 Ea (1 ea)	100-Small Fab
C45-3-9	Lever Spring ✓	1 pcs (1 ea)	100-Small Fab
C45-4-1	Trunnion Bushing ✓	2 Ea (2 ea)	100-Small Fab
C45-5-1 P	Lever Stop Pin ✓	1 Ea (1 ea)	100-Small Fab
C45-7-1 P	LOADBEAM BUMPER ✓	1 Ea (1 ea)	100-Small Fab
C45-7-2	Lock Bumper ✓	2 Ea (2 ea)	100-Small Fab
C45-8-4	Solenoid Cover Gasket ✓	1 Ea (1 ea)	100-Small Fab
MS21044N5 P	Nut ✓	4 Ea (4 ea)	100-Small Fab
MS27039-4-08	Screw ✓	1 Ea (1 ea)	100-Small Fab

5078801
5089520
5078803
5029329
5019332
5095587
5094821
5057526-1
5039330

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NAS1149F0463P	3	747	0
	NAS1149F0563P	8	626	0
100-Small Fab	188-FPSS-1/4 20-3/8	2	0	0
	188-FSCS-1032-5/8	4	377	0
	600.1309-A	1	0	0
	600.1312	1	22	0
	AN4-23A	2	588	0
	AN5-21A	4	73	0
	C2-14-2	2	206	0
	C45-10-1	1	91	0
	C45-10-2	1	11	0
	C45-11-2	2	78	0
	C45-12-1	2	16	0
	C45-12-6	2	84	0
	C45-13-1	2	13	0
	C45-13-2	2	82	0
	C45-13-5	1	95	0
	C45-3-1	2	18	0
	C45-3-12	1	12	0
	C45-3-2-1	2	54	0
	C45-3-4-1	4	156	0
	C45-3-5	2	78	0
	C45-3-8A	1	57	0
	C45-3-8B	1	38	0
	C45-3-9	1	0	0
	C45-4-1	2	48	0
	C45-5-1	1	41	0
	C45-7-1	1	0	0
	C45-7-2	2	12	0
	C45-8-4	1	0	0
	MS21044N5	4	139	0
	MS27039-4-08	1	78	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

095-13-1



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
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